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D4634-145

Job Sheet 167078-M



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Job Created: 10/24/17

Due Date: 11/10/17

Type: SOLD

Ship Via:

Priority: Medium

D4634-5 x1
D5021-5 x1
Done

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5	1	3	0	0
	D4636-5 5033775	1	43	0	0
	D4647-1 5033772	1	4	0	0
	D4664-5 5033769	6	39	0	0
	D4712-1 5033768	1	4	0	0
	D4732-17 5033766	1	0	0	0
	D4732-23 5033765	1	1	0	0
	D4732-27 5033764	1	1	0	0
	D5021-5	1	1	0	0
	MPNY-750S-9-C 50337629		570	0	0
	MS20426AD3-4 5033754		5,055	0	0
	MS20426AD4-6 5033752		2,797	0	0
	MS21059L08 5033756	2	62	0	0

Part Specifications

Specifications could not be found.